

Work Order ID 82152

Friday, March 23, 2012 1:25:03 PM

82152

Page 1

Item ID: D3536-11

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Gasket

Start Date: 3/23/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 3/30/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date: 12-03-23 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3536	Rev A

100

0.00

100

FLOW WATER JET

0.00

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3536 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

B / Jm 120403 (12)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B / Jm 120403 (12)

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

Siz/4/04

(12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 82152

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Page 2

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Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Gasket

Start Date: 3/23/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 3/30/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop

NR2

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location

0.00

130

Packaging

Memo

0.00

Packaging

(2x) SP 12-04-05

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/4/5
12-04-5

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NOTE: Date & initial all entries

Picklist Print

Friday, March 23, 2012 1:25:08 PM

Page 1

Work Order ID: 82152

82152

Parent Item: D3536-11

D3536-11

Parent Item Name: Gasket

Start Date: 3/23/2012

Required Date: 3/30/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	801.7520	0.6728	8.970667			

MNEO60S 063

**

NEOPRENE SHEET 0.063

Location

Loc Qty

Loc Code

MAT052

801.752

119777

3.752

120948

798

120948 Jm/1B 120403.12

Dart Aerospace Ltd

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	82152
Description: Gasket		Part Number:	D3536-11
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.65	+/-0.030	26.65	✓		MT	HB-01
23.15	+/-0.030	23.15	✓		MT	HB-01
21.15	+/-0.030	21.15	✓		MT	HB-01
17.65	+/-0.030	17.65	✓		MT	HB-01
13.40	+/-0.030	13.40	✓		MT	HB-01
9.15	+/-0.030	9.15	✓		MT	HB-01
5.65	+/-0.030	5.65	✓		MT	HB-01
3.90	+/-0.030	3.90	✓		Vern	HB-02
8.00	+/-0.030	8.00	✓		Vern	HB-02
14.00	+/-0.030	14.00 14.00	✓		MT	HB-01
1.89	+/-0.030	1.893	✓		Vern	HB-02
0.30	+/-0.030	0.30	✓		Vern	HB-02
0.30	+/-0.030	0.30	✓		Vern	HB-02
Ø0.19	+0.005/-0.001	0.192	✓		Vern	HB-02

Measured by: RB/Jm.	Audited by: S	Prototype Approval:	N/A
Date: 120403	Date: 26/04/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.07	New Issue	KJ/EC	

Dart Aerospace Ltd

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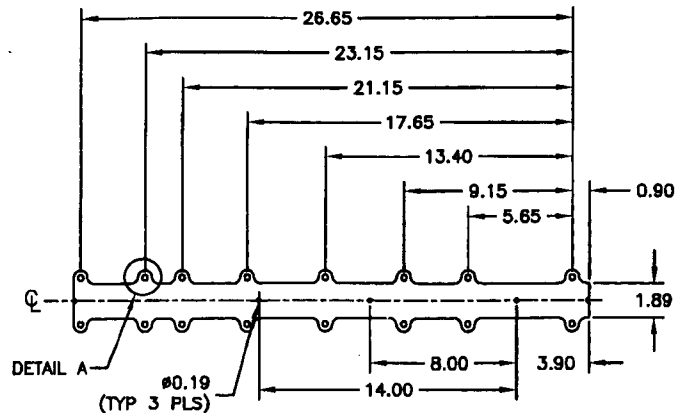
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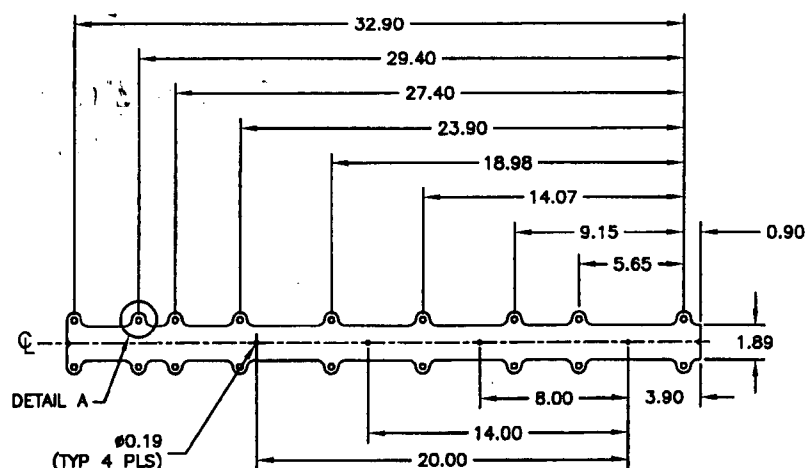
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09-02-12

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82152

12-03-23



D3536-11 GASKET



D3536-13 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	CB	PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3536	REV. A
DATE 06.10.25	TITLE GASKET	SHEET 1 OF 6	SCALE 1:10
A	06.10.25	NEW ISSUE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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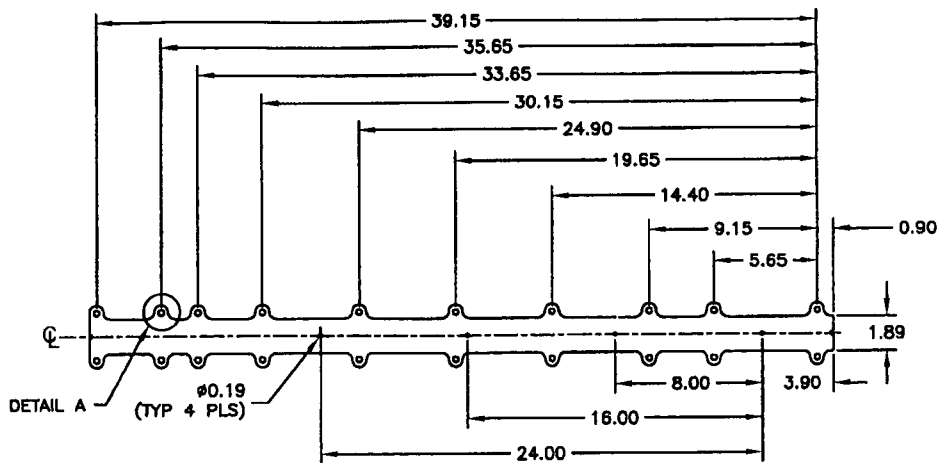
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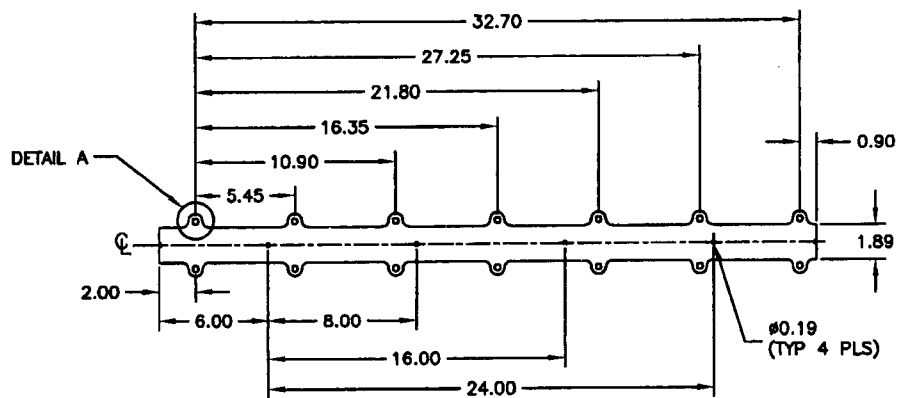
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 2 OF 6
				SCALE 1:10

RELEASED
07.02.12

82152



D3536-15 GASKET



D3536-21 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

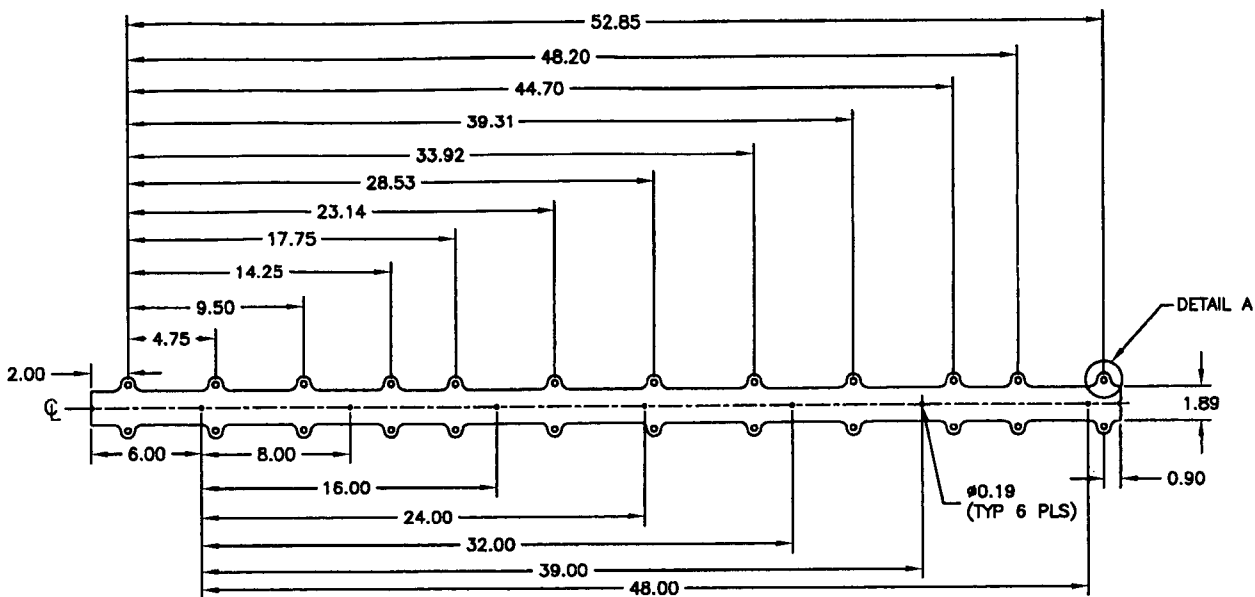
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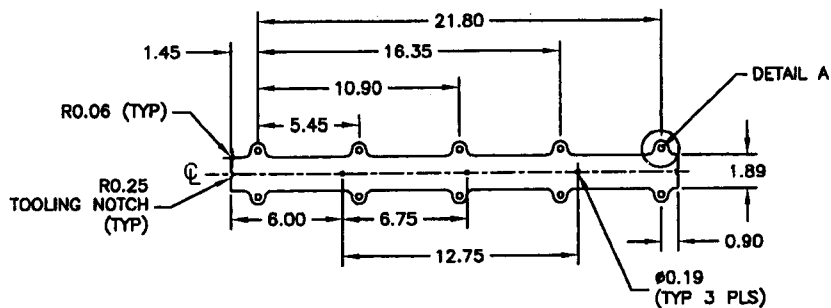
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CHECKED	MH	APPROVED	MH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 3 OF 6
		SCALE	1:10	

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07.02.12



D3536-23 GASKET

82152



D3536-25 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CL
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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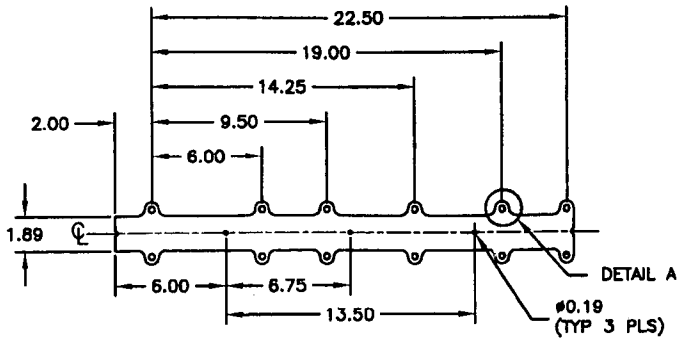
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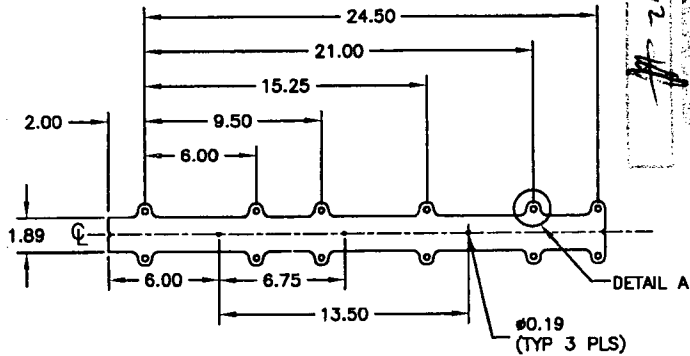
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CHECKED	PH	APPROVED	PH	DRAWING NO.	D3536
DATE	06.10.25			TITLE	GASKET
				REV. A	SHEET 4 OF 6
				SCALE	1:10

02.02.12 *[Signature]*

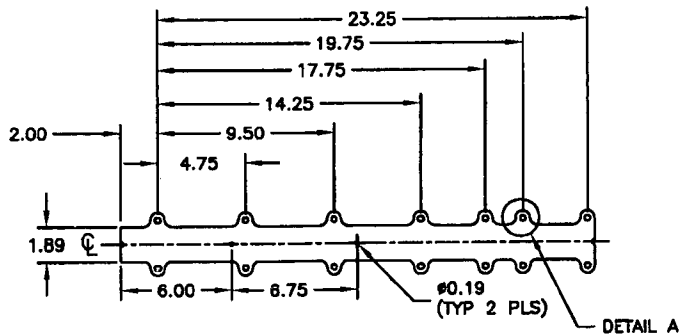


D3536-31 GASKET



D3536-33 GASKET

82152



D3536-35 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
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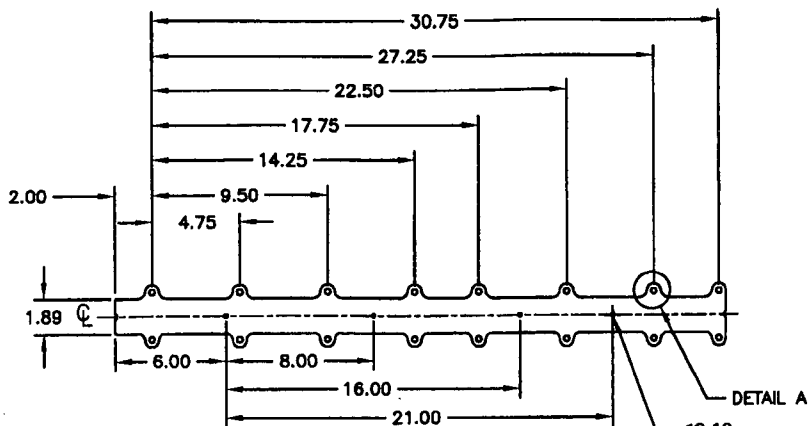
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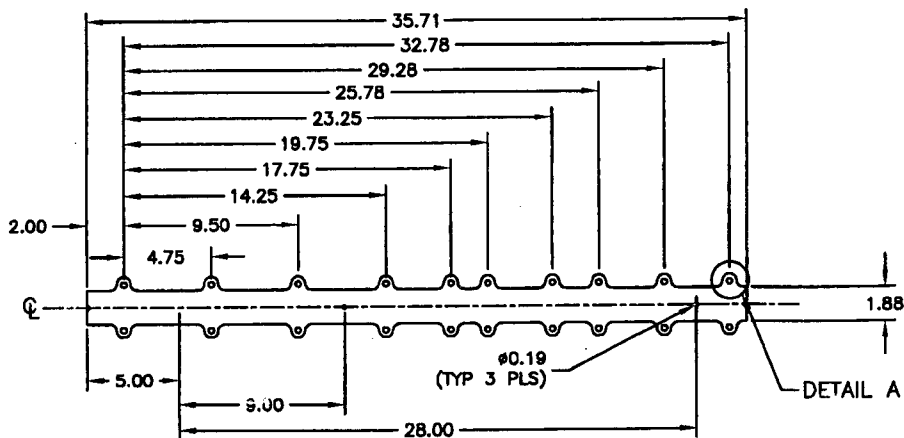
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DESIGN	C.B.	DRAWN BY	C.B.	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	GASKET	REV. A
		DRAWING NO.	D3536	SHEET 5 OF 6
		SCALE	1:10	



D3536-37 GASKET

82152



D3536-39 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 80 DUROMETER (REF DART SPEC. M-NE080-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
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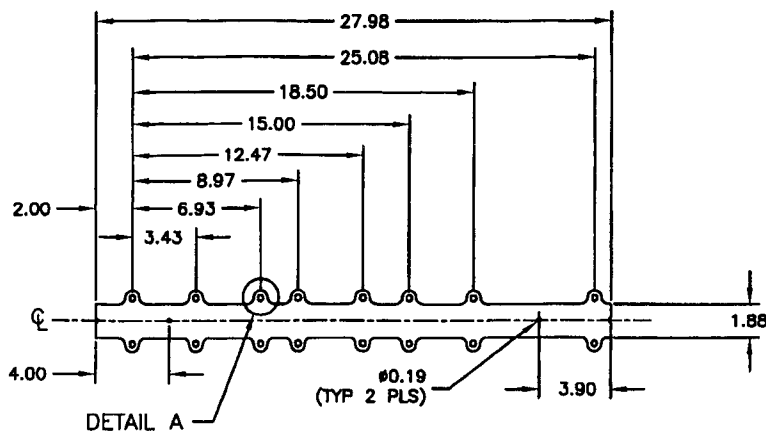
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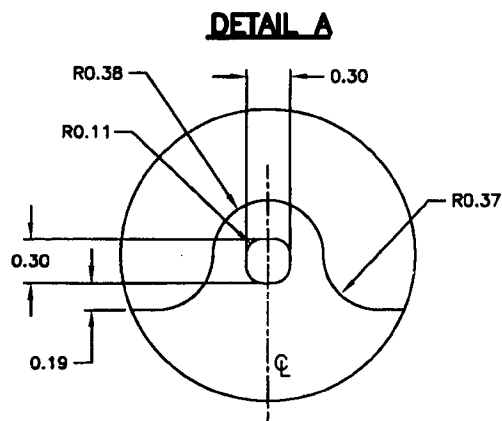
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DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 6 OF 6
		SCALE	1:10	

0702.02 *CH*



D3536-41 GASKET



NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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